

Work Order ID 123565

Tuesday, August 12, 2014 11:44:26 AM

123565

Ship Friday Page 1

Item ID: D4982-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Upper Cutter Assembly
 Start Date: 8/12/2014 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 8/15/2014 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MF Date: 14-8-12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4982	C								
110	Pick Kit	0.00							DAS 41 9-89
110									
Packaging	Memo	0.00				1			14-8-14
Packaging									
120		0.00							DAS 41 9-89
120									
Small Fab	Memo	0.00				1			14-8-14
Small Fab	Torque hardware as per dwg								

Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 8.

A/R RTV LOCTITE 598: 125540
 exp. date: 5/15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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Page 2

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130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>ST.</u>	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

(2)

DAS 16 9-89 38 14/08/14 14/08/14

MF. 14-8-14

MUS 14-08-15

MF 14-8-14

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Picklist Print

Tuesday, August 12, 2014 11:44:25 AM

Page 1

Work Order ID: 123565

123565

Parent Item: D4982-041

D4982-041

Parent Item Name: Upper Cutter Assembly

Start Date: 8/12/2014

Required Date: 8/15/2014

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 13.011.20 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5140-1 *D5140-1* Upper Cutter Body, LH		Manufactured	No				Each	4.0000	**	2		DAS 41 9-89 14-8-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		4							
				122765		4							
D5140-2 *D5140-2* Upper Cutter Body, RH		Manufactured	No				Each	4.0000	**	2		DAS 41 9-89 14-8-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				CA		4							
				122766		4							
D4839-1 *D4839-1* Blade		Manufactured	No				Each	14.0000	**	4		DAS 41 9-89 14-8-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		14							
				109514		14							
D4973-1 *D4973-1* Upper Cutter Deflector		Manufactured	No				Each	4.0000	**	2		DAS 41 9-89 14-8-14	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MF		4							
				122828		4							

DQA: _____ Date: _____

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Transport									
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FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
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Picklist Print

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Page 2

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123565

Parent Item: D4982-041

D4982-041

Parent Item Name: Upper Cutter Assembly

Start Date: 8/12/2014

Required Date: 8/15/2014

Start Qty: 2.00

Required Qty: 2.00

D4974-1 Manufactured No

Each 4.0000 2

D4974-1

DAS
41
9-89

14-8-14

Upper Rail

Location

Loc Qty

Loc Code

CA

4

122787

4

2

NAS1149CN832R

Purchased

No

Each

827.0000

56

DAS
41
9-89

14-8-14

NAS1149CN832R

Washer

Location

Loc Qty

Loc Code

ST278

827

116038

27

124580

600

125268

200

56

MS27039C0819

Purchased

No

Each

72.0000

28

DAS
41
9-89

14-8-14

MS27039C0819

Screw

Location

Loc Qty

Loc Code

ST308

72

m127581

72

28

MS21043-08

Purchased

No

Each

188.0000

28

DAS
41
9-89

14-8-14

MS21043-08

Nut, Self Locking

Location

Loc Qty

Loc Code

ST306

188

123900

188

28

Tuesday, August 12, 2014 11:44:26 AM

Shop Packet Print

Page 2

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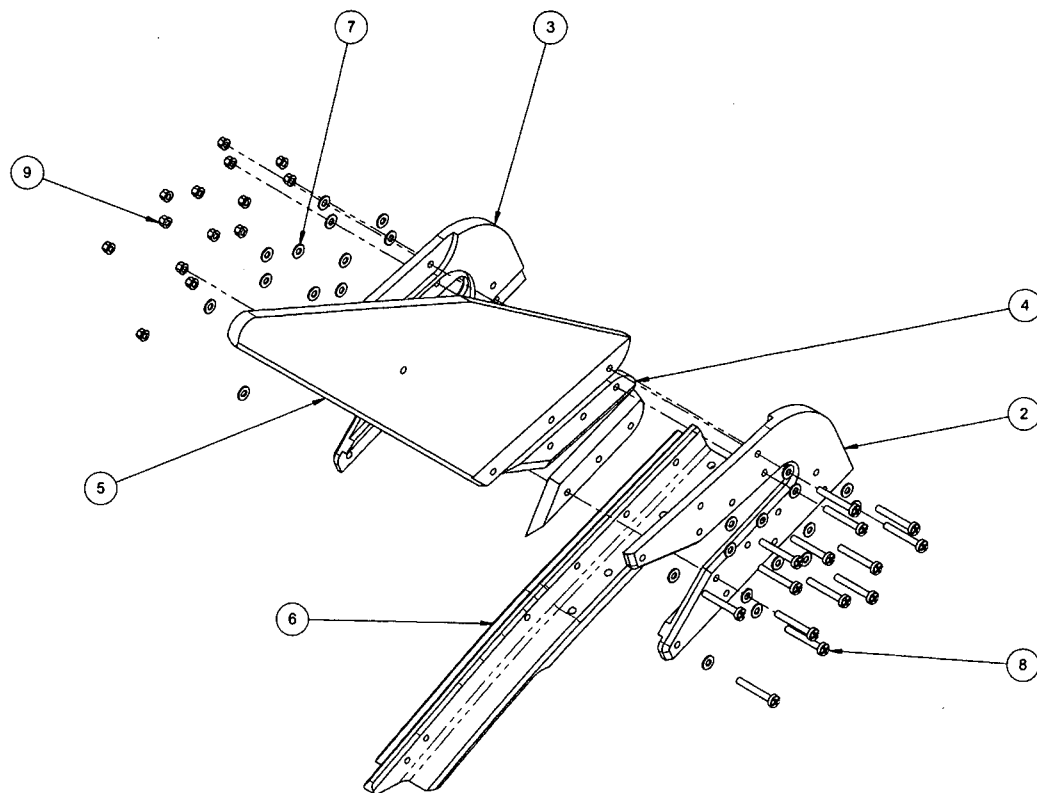
8 7 6 5 4 3 2 1

D

C

B

A



D4982-041 UPPER CUTTER ASSY

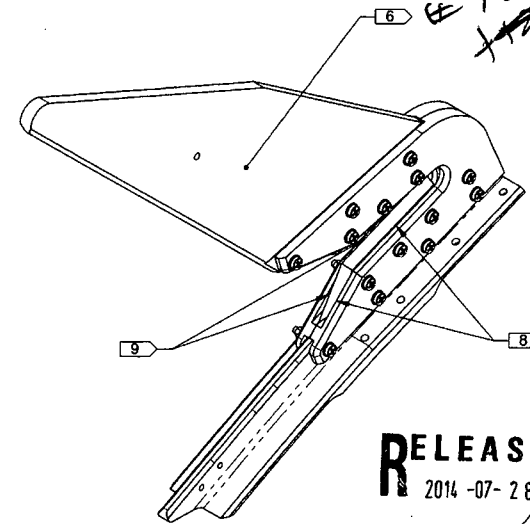
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4982-041", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
- 7) WEIGHT: 4.46 lbs (2.03 kgs)
- 8) APPLY RTV SEALANT TO ALL FAYING SURFACES UPON ASSEMBLY
- 9) CUTTING EDGE INTENDED TO BE SHARP. DO NOT BREAK SHARP EDGE.
- 10) TORQUE HARDWARE TO 12-15 in-lbs (1.4-1.7 N-m)

8 7 6 5 4 3 2 1

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4982-041	UPPER CUTTER ASSY
2	1	D5140-1 ✓	UPPER CUTTER BODY LH
3	1	D5140-2	UPPER CUTTER BODY RH
4	2	D4839-1	BLADE
5	1	D4973-1	UPPER CUTTER DEFLECTOR
6	1	D4974-1	UPPER RAIL
7	28	NAS1149CN832R	WASHER
8	14	MS27039C0819	SCREW
9	14	MS21043-08	NUT

△
C



RELEASED
2014-07-28

C	REVISED BILL OF MATERIALS	AK	14.07.18
B	REVISED D4973-1 (ZN C3-1) AND D4974-1 (ZN B2-1)	AK	14.05.26
A	NEW ISSUE	DC	13.11.18
REV.	DESCRIPTION	BY	DATE
DESIGN	DC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	JFS	D4982	SHEET 1 OF 1
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	UPPER CUTTER ASSY	NTS
DATE	14.07.18	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED

DQA: _____ Date: _____



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